Work Order ID 77753 *77753* Page 1 December-21-11 8:23:38 AM Item ID: D212-664-101TRN Accept *N900040100* Setup Start **Revision ID:** Crosstube Turning Detail **Item Name: Start Date:** 21/12/2011 Start Qty: 1.00 **Cust Item ID: Required Date:** 04/01/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: M.L.J Date: 11 12 7 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Code Qty Run Hours **Qty** Number Stamp **Draw Nbr Revision Nbr** D212-664-141 Rev D (DEO) 100 0.00 MORI SEIKI CNC LATHE LARGE *100* Mori Seiki 0.00 Memo Mori Seiki CNC Lathe Large 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113 2-Turn first side as per Folio FA113 mmol 12/01/02 3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit. 110 QC1- Inspect dimensions to dimension sheet 0.00 *110* QC 0.00 Memo gngn.L 12/01/02 Quality Control

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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA :_	Date: _	. Live
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DATE	CTED	Description of NC		Corrective Action Section		Verificati	on Approval	Approval
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Work Ord December-21-				*777	753*						Page
Item ID: Revision ID:	D212-664-1			Accept	*N900	040	10) *	Setup Sta	1 \	IS1*
Item Name:	Crosstube Tu	rning Detail							Sto	ob */	IS2 *
Start Date:	21/12/2011	Start Qty: 1.00	*1*		Cust Item	ID:					
Required Date	e: 04/01/2012	Req'd Qty: 1.00	*1*		Customer:						
Reference:			-								
Approvals:	Process Plan:		Date:	Tooling:	Date:			F	Run Sta		R1*
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	^{op} *N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		MORI SEIKI CNC LATI	HE LARGE					1	C		
Mori Seiki		Memo		0.00				<u>t</u>	- - Y		
Mori Seiki CNC L	athe Large	1-Turn secon	nd side as per Folio FA1	13					•		
		*Use mill ba	sition lines only, **do n stard file, brush file repe sandpaper coarser than 3	eatedly with file card.			W	ngni		12/0	1/02

3-Remove sand and plugs

QC1- Inspect dimensions to dimension sheet 0.00

*Do not use sandpaper coarser than 320 grit. FOLIO REV: ______

130 QC

130

Memo

FOLIO REV:_ DWG REV:_

0.00

Quality Control

MM-L 12/01/02

Page 2

W/O:		WORK ORDER CHANGES												
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DATE	STEP Description of NC			Corrective Action Section B				cation	Approval	Approval				
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77753

· Page 3

December-21-11 8:23:38 AM Item ID: D212-664-101TRN Accept *N900040100* Setup Start **Revision ID:** Crosstube Turning Detail Item Name: **Start Date:** 21/12/2011 Start Qty: 1.00 **Cust Item ID: Required Date:** 04/01/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: Stop Date:_____ QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description Qty **Run Hours** Code Qty Number Stamp QC8- Inspect parts - second check 140 0.00 12-1-2 *140* 0.00 Memo Quality Control 145 0.00 *145* Crosstubes 0.00 Memo 12-1-3 Crosstubes GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY 150 Crosstubes Chemical Conversion 0.00 12-1-3 *150* HandFXtube 0.00 Memo Hand Finishing Crosstubes

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		Description of NC		Corrective Action Section	on B	Verification	Approval	Approval
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Chief Eng Chief Eng Date

December-21-1				*777	753*						Page 4
Item ID: Revision ID: Item Name:	D212-664-10			Accept	*N900	0401	იი*	Setup	Start Stop	*NS	1*
Start Date: Required Date: Reference:	21/12/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:				ריאו	
Approvals:	Process Pla	n:	Date:	Tooling:	D	ate:		Run	Start	*NR	1*
	QC:		Date:	SPC (Y/N):	D	ate:			Stop	*NR	2*
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160 QC Quality Control		Memo		0.00				<i></i>	2	/_	4
170		Dookoging		0.00		,		, ,	1		
170 Packaging		Packaging Memo		0.00					<u> </u>		
Packaging		Identify and Location:	Stock in kanban rack)	MA	M. C	10	2/6)/	03
180		QC21- Final Inspection	Work Order Release	0.00				1		/ 7聲	en i julius Parkija julius
*1 R O * QC Quality Control		Мето		0.00			<u></u>	K 1-	2/0	105 MC 12	-01-0U

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December-21-11 8:23:42 AM

Work Order ID: 77753

77753

Parent Item:

D212-664-101TRN

D212-664-101TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 21/12/2011

Required Date: 04/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 08-03-06 new issue DD verified by:ec

IPP Rev B 08.04.02 removed Polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6005-128		Manufactured	No			120	Each	6.0000	1	1			
D6005-13	28								**				

Crosstube Material

Location Loc Qty Loc Code LG 6

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W/O:			W	ORK ORDER CHANG	ES				
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Item	Qty -141	Qty -141B	Part Number	Description
1	Х		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		Х	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6005-128

FINISHED LENGTH = 126.514±0.020

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
 - D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE
- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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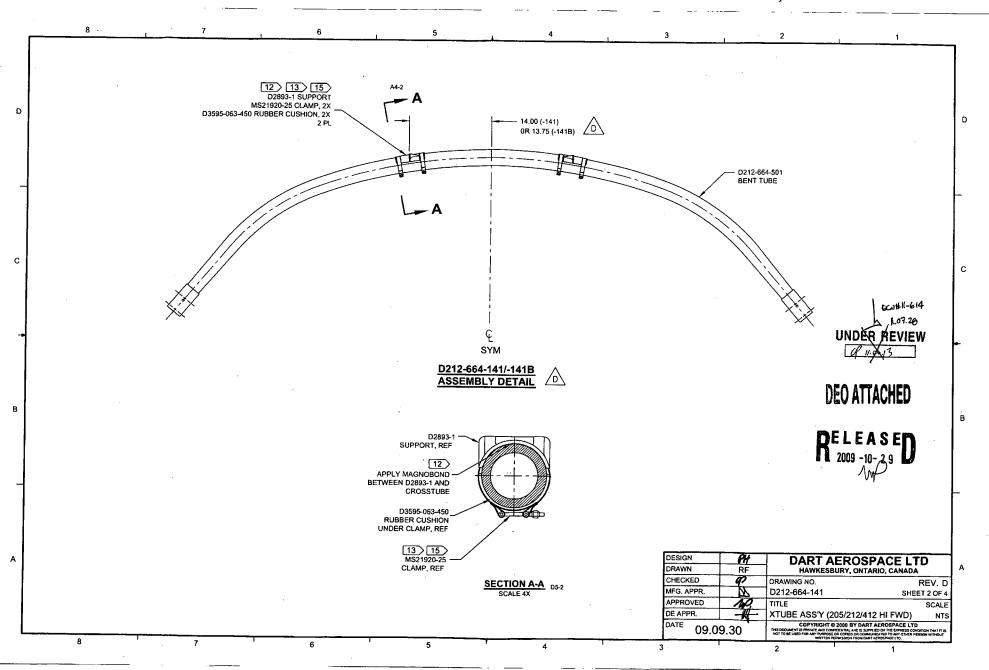
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D .	REORG TO CUP REMOV & B6-3);	ANIZED VIEWS RRENT STAND (ED REF & ADE RELOCATED) TURNING DE	JENEKAL NOTES/FART LIST; S AND REFORMATTED DRAWING ARDS; ADD -141B (ZN B4-2, D4-2); D TOLERANCES (ZN B4-3, C6-3, C6-3 FLAG #6 PER PAR 08-046 (ZN A5-3); TAIL & UPDATED TOLERANCE TO	RF	09.09.30		
С			SION STRIP; ADD MAGNOBOND /ERSE CLAMPS	PH	07.03.08		
8	ADD H SKIDTI		OMPATABILITY WITH BHT/AA	PH	05.02.04		
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REV.			DESCRIPTION	BY	DATE		
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CHECK	D	97	DRAWING NO.		REV. D		
MFG, AF	PR.	77	D212-664-141	9	SHEET 1 OF 4		
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DE APP	R.		XTUBE ASS'Y (205/212/412	HI FWI	D) NTS		
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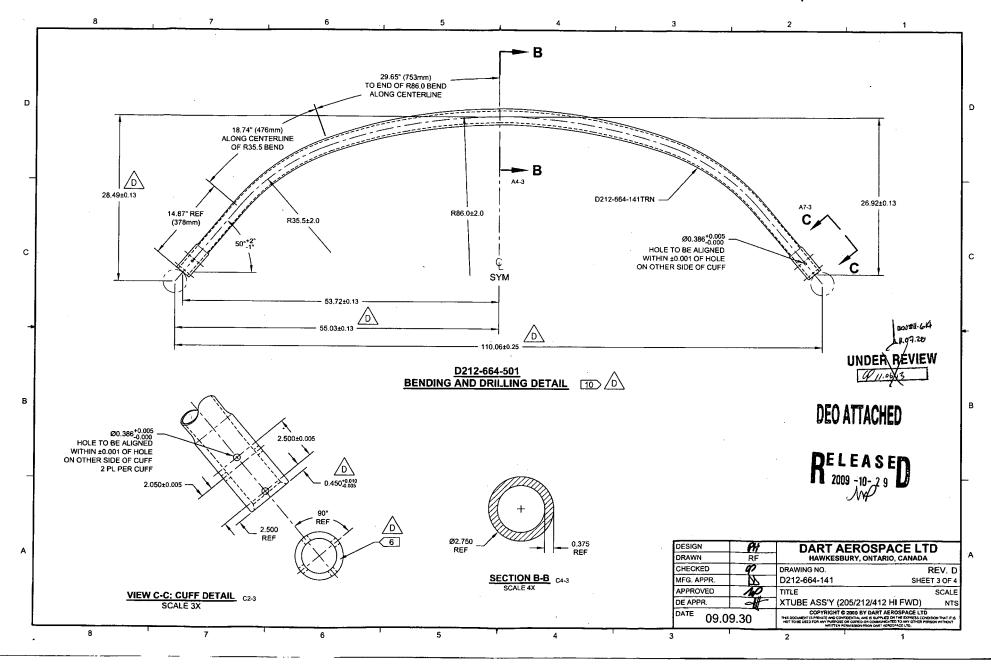
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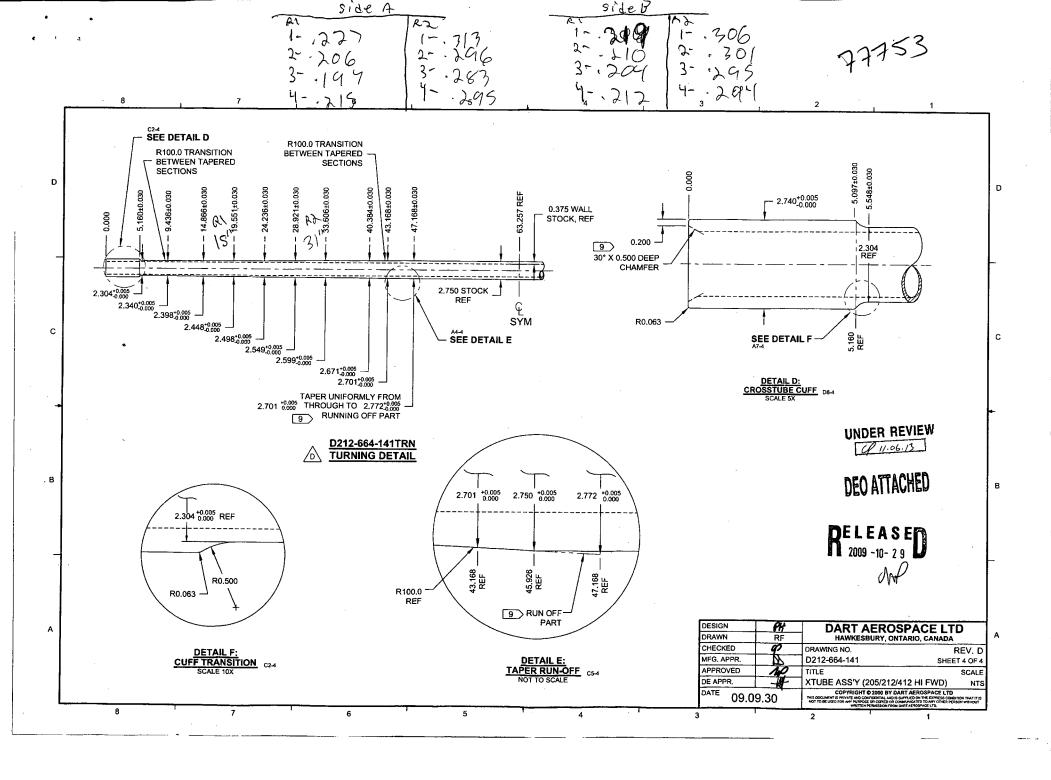
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DRAWING NO.	TITLE		REV. D	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D212-664-141	XTUBE ASS	Y (205/212/412 HI	FWD)	ENGINEERING ORDER	D212-664-141-D-1	SHEET 1 OF 2	NTS
DRAWN		CHECKED /	R	MFG. APPR. &	APPROVED AND	DE APPR.	
DATE 11.04	.07	DATE))	\ (¹ / ₂),))	DATE ((.04.12	DATE 11/04/12	DATE 11.04.12	

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

<u> 15:</u>

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND

PAINT OUTSIDE PER DART QSI 005 4.2 REMOVE MASKING AND APPLY CLEAR COAT

WAS:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2

PAINT OUTSIDE PER DART QSI 005 4.2

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W/O:			M	ORK ORDER CHANG	ES		•		
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	Section C	Chief Eng	QC Inspector
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DRAWING NO. DART AEROSPACE LTD TITLE REV. D D.E.O. NO. SHEET NO. SCALE XTUBE ASSY (205/212/412 HI FWD) **ENGINEERING ORDER** D212-664-141 D212-664-141-D-1 SHEET 2 OF, 2 NTS DRAWN CHECKED MFG. APPR. APPROVED DE APPR. 11.04.07 DATE 11/04/12 DATE DATE 1.04.1 11.04.12 DATE DATE 11.04.12 UNDER REVIEW 100 # 11.614 IS: WAS: D212-664-501 BENT TUBE D212-664-141/-141B **ASSEMBLY DETAIL** MASK AREA PRIOR TO PAINTING, REMOVE MASKING AFTER PAINT AND APPLY CLEAR COAT 2.0 -COPYRIGHT © 2011 BY DART AEROSPACE LTD

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DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr Part No:PAR #:Fault Category:NCR: Yes No DQA:Date: Resolution:Disposition:QA: N/C Closed:Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NCCorrective Action Section B										
	Re	solution:	Dispositio	on:	_ QA: N/(Clos	ed:		Date: _	
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DRAWING NO.	TITLE REV. D	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D212-664-141	CROSSTUBE ASS'Y (205 HI FWD)	ENGINEERING ORDER	D212-664-141-D-2	SHEET 1 OF 1	NTS
DRAWN //	CHECKED A>>	MFG. APPR	APPROVED AND	DE APPR.	
DATE 11.0	.15 DATE 11.07.20	DATE 11.07.21	DATE 11/01/21	DATE 11.07.21	

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

item	Qty -141	Qty -141B	Part Number	Description
7	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023
			-	ADHESIVE (TEXTRON/BELL SPEC. 299-947-100,
				TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

10

- 12) TO INSTALL D2893-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04° TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	3							_			
Part No:		PAR #:	_ Fault Cat	Fault Category:NC			NCR: Yes No DQA: Date:				
	R	esolution:	Disposition: C			QA: N/C Closed: Date					
NCR:		W	ORK OR	DER NON-CONFORMA	ANCE	(NCR					
DATE	STEP	Description of NC	Corrective Action Section			Cian 0	Verifica		Approval		
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sectio	Section C	Chief Eng	QC Inspector	
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DART AEROSPACE LTD	Work Order:	77753
Description: Crosstube Assembly (205/212/412 High Fwd)	Part Number:	D212-664-141
Inspection Dwg: D212-664-141 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	•
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Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	0.200	+/-0.010	3200	V		vern	CWCLOR
1	R0.063	+/-0.010	. 063	$\sqrt{}$		A6	
:	2.740	+0.005/-0.000	2-742			vern	CWC-08
	5.097	+/-0.030	5.095			1	
	2.304	+0.005/-0.000	2.309				
_	2.340	+0.005/-0.000	2-7-45				
EA	2.398	+0.005/-0.000	2-403	/			
SIDE	2.448	+0.005/-0.000	2.4153				
,	2.498	+0.005/-0.000	2,501	,			
	2.549	+0.005/-0.000	2-554				
	2.599	+0.005/-0.000	2.603				
	2.671	+0.005/-0.000	2.673				
	2.701	+0.005/-0.000	2-702	J		,	
				,			
	0.200	+/-0.010	,200			virn	CN (-08
1	R0.063	+/-0.010	. 06ን			K6	,
0.00	2.740	+0.005/-0.000	2-7-10			vern	CN C-04
. 1	5.097	+/-0.030	5.095			\	<u> </u>
,	2.304	+0.005/-0.000	2.309				
	2.340	+0.005/-0.000	2-345				
E B	2.398	+0.005/-0.000	2-402				
SIDE	2.448	+0.005/-0.000	2-453				
	2.498	+0.005/-0.000	2-501				
	2.549	+0.005/-0.000	2 554	_			
	2.599	+0.005/-0.000	2-607				
	2.671	+0.005/-0.000	2,673				
	2.701	+0.005/-0.000	2.703	- /		J	
	126.514	+/-0.020	126.520	Δ		ture	91971.02

Measured by: 9900, L	Audited by:	Prototype Approval:	N/A
Date: 12/01/02	Date: 3-/-2	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
В	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
С	07.05.28	Dwg Rev updated	KJ/JLM ,	11
D	10.02.02	Dimension 126.514 was 126.51	KJ X	M

Dart Aeı	ospace	e Ltd		·				
W/O:			W	ORK ORDER CHANGES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	\$27	, in the second	*					
· .				•				
Part No		PAR #:	Fault Cate	egory: N	CR: Yes	No DQA:	Date: _	
	R	esolution:	Disposition	on: Q	A: N/C Cld	sed:	Date: _	
NCR:	٠.	v. V	VORK ORE	DER NON-CONFORMANC	CE (NCR)		•
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

L	0.2.	Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector
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